

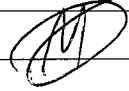
Work Order ID 133606

Thursday, June 11, 2015 12:51:49 PM

133606

Page 1

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Inboard RH
Start Date: 6/11/15 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 6/19/15 Req'd Qty: 5.00 ***5*** Customer:
Reference: REWORK AS PER ECN15-575

Approvals: Process Plan:  Date: 5-6-11 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3884	C								

130 Chemical Conversion Coat per QSI005 4.1 0.00

130

HandFinish

Memo

Hand Finishing

PULL FROM STOCK
D3884-2 X5
B129067

REMOVE PAINT INSIDE SADDLE
AS PER ECN 15-575

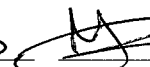
150 QC3- Inspect Part Finish 0.00

150

QC

Memo

Quality Control

5  5-6-11

Pb-7

5 DAS
41
9-89

DQA: Ant Date: 15/07/08

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RPM Date: 15/07/08Work Order update only ☐

Work Order: <u>133606</u> Part No. <u>D3884-2</u> NCR No. <u>15-5177</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☒ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐			
Date: <u>15/06/22</u>	Step #: <u>100</u>	QTY Effective: <u>x5</u>		MRB (QSI042) Approval <u>5/15/06/22</u>	
Description Work Order Deviation		Disposition		Completed By DAS 41 15-6-24 9-89	
Due to Applying "Paint Striper" some of the Powder coat has been removed from the outer surface. Re. Process Design change & manufacture process		Acceptable to touchup powder coat as per Q22005 1. Clean area thoroughly 2. Apply "Imron Paint" as per Q22005 3. Gentle wet sand to remove any high spot 4. Repeat steps 2 + 3 if required		Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>15-07-03</u>	
Root Cause Environment ☐ Design ☐ Doc/Data ☒ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ ☒ Manufacturing Process Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ ☒ Drawing Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER: ☐					

Work Order ID 133606

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133606

Page 2

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Reference: REWORK AS PER ECN15-575

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>SI 404</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging	REPACKAGE USING NEW BATCH NUMBER								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

5x. DAS 26 9-89 JUN 2 5 2015

ML5 JUN 2 9 2015

ML5 JUN 2 9 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Picklist Print

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Page 1

Work Order ID: 133606

133606

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inboard RH

Start Date: 6/11/15

Required Date: 6/19/15

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV:B

15.05.20 remove inside powdercoat DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3884-2

Manufactured No

Each 6.0000

D3884-2

Saddle, Inboard RH

**

Location

Loc Qty

Loc Code

ST404

6

127624

4

129067

2

5

~~ABS-6-11~~

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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